

Date: Wednesday, 9/13/2006 4:29:55 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET ADAPTER
Job Number : 28520	
Estimate Number : 12174	
P.O. Number : <i>N/A</i>	Part Number : D3478041
This Issue : 9/13/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3478 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 26539	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/6/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 06-02-03 JLM	
Est Rev: B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34783	TUBE
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3478-3 Tube *B28570*

2.0	D34781	FLANGE
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3478-1 Flange *B28569*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3478

*mf.**06/10/03**(4)*

2-Spot Weld as per Dwg D3478 and Dart QSI 018

*mf.**06/10/03**(4)*

4.0	QC5/11	INSPECT WORK/INSPECT SPOT WELD
-----	--------	--------------------------------



Comment: INSPECT WORK/INSPECT SPOT WELD

*SB**06/10/03**(4)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *LD* Date: 06/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:29:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET ADAPTER

Job Number: 28520

Part Number: D3478041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: 57446

06/10/04 (4)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

SD 06/10/04

Job Completion



06/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

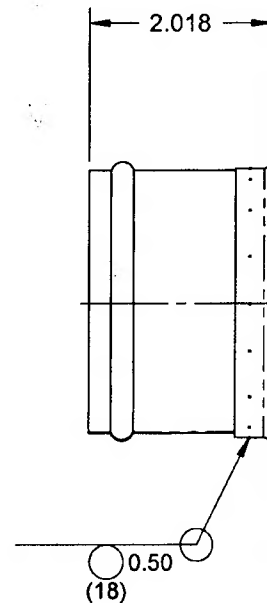
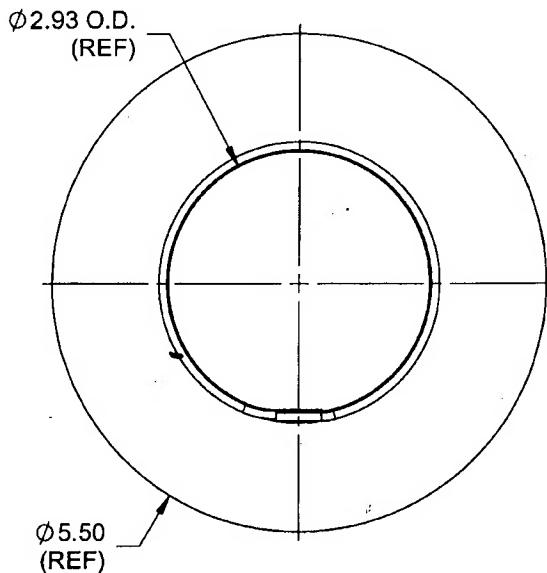
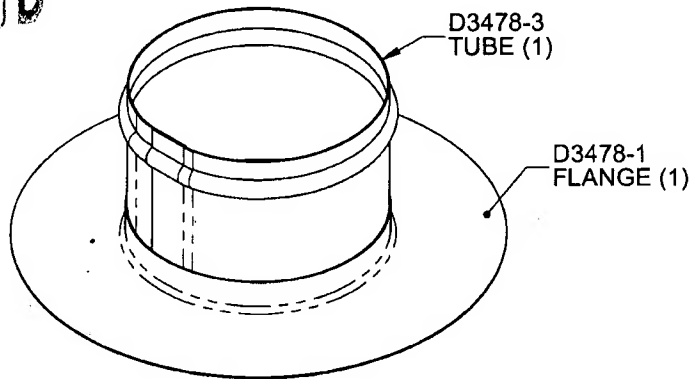
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3478	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2
A	05.12.08	NEW ISSUE	
B	06.05.16	REDESIGN D3478-5, ADD D3478-7, D3478-9S/-9	

RELEASED
06-05-16 *H*



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D3478-041 AIR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3478-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

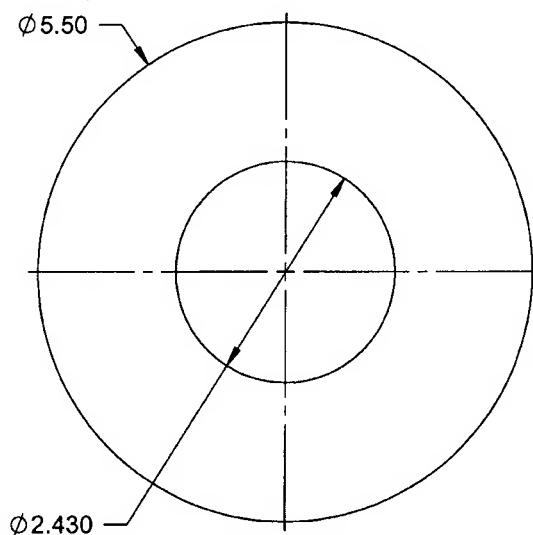
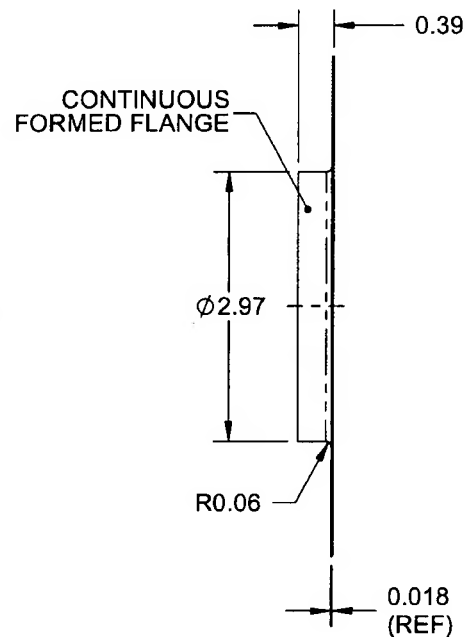
QTY -041	P/N	DESCRIPTION
X	D3478-041	AIR INLET ADAPTER
1	D3478-1	FLANGE
1	D3478-3	TUBE

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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06-05-16**D3478-1F FLANGE**
FLAT PATTERN**D3478-1**
FLANGE**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

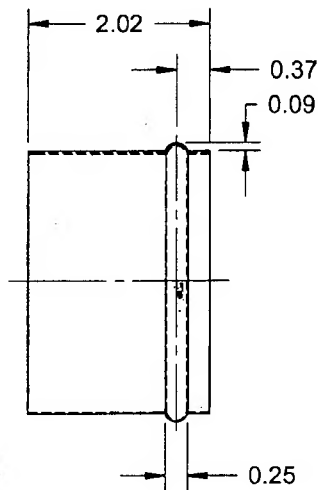
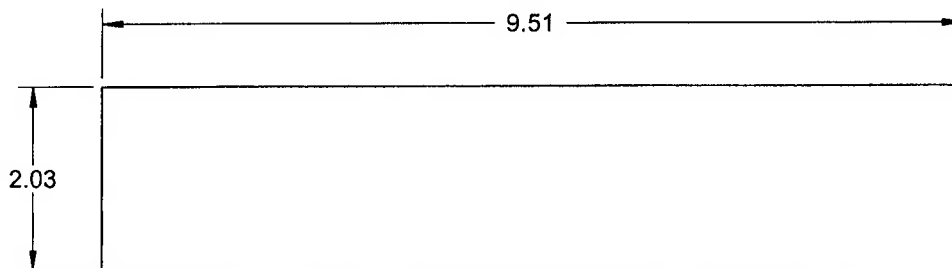
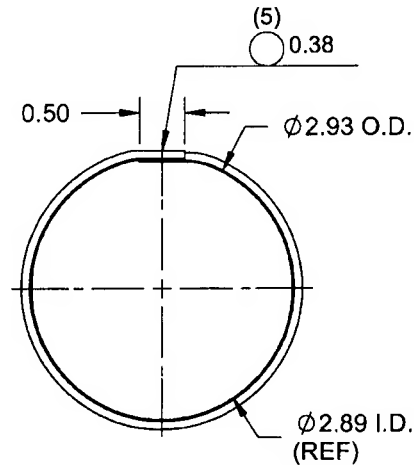
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DATE 06.05.16	TITLE AIR INLET ADAPTER		SCALE 1:2

RELEASED
06.05.16 #**D3478-3 TUBE****D3478-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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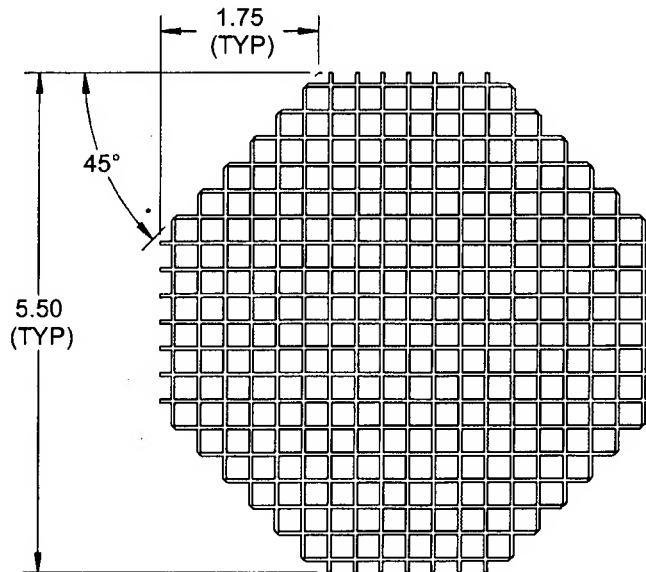
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16 H



D3478-5 SCREEN

NOTES:

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING, ϕ 0.047" WIRE
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

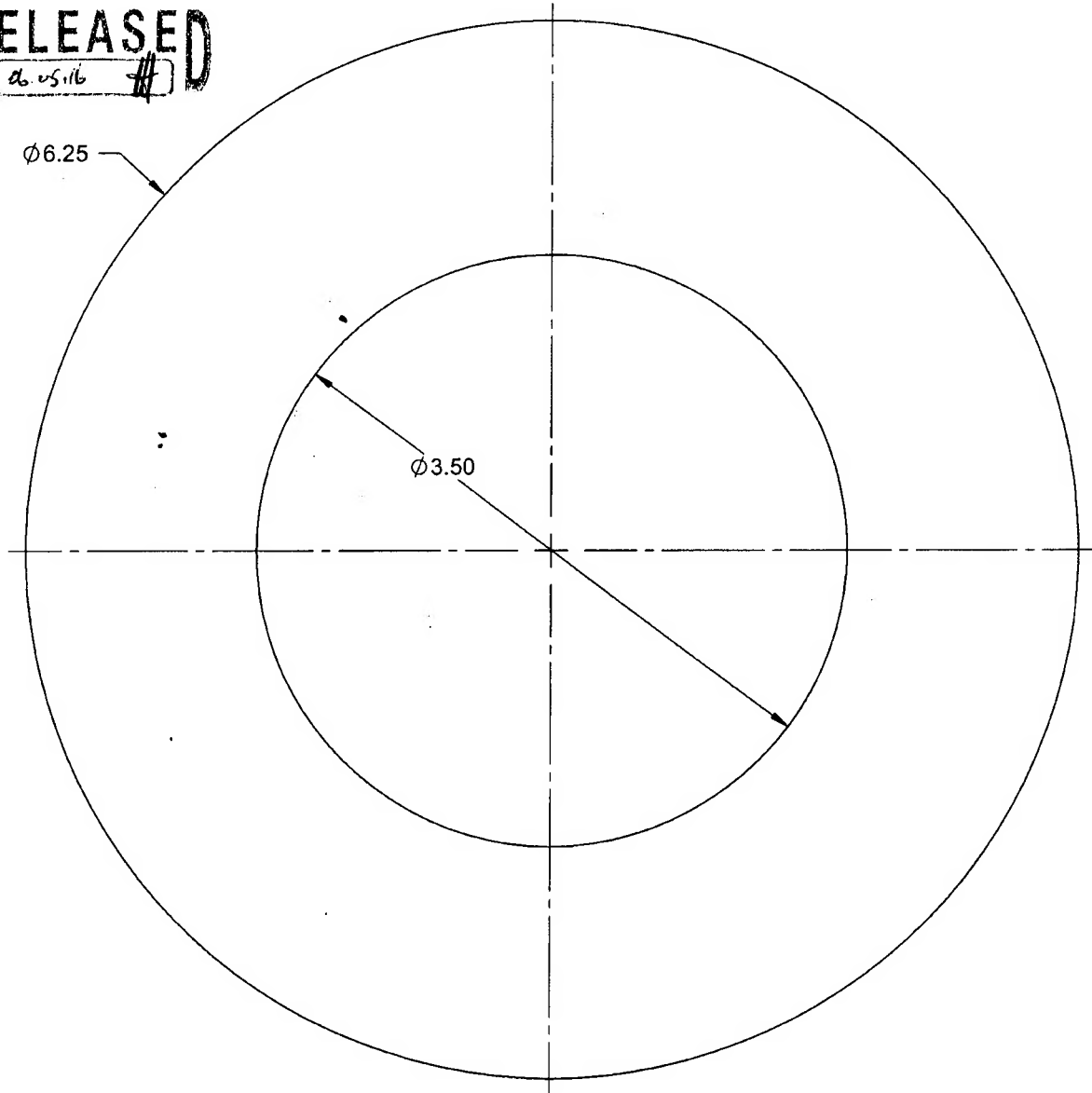
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:1

RELEASED
06.05.16 #**D3478-7 INLET GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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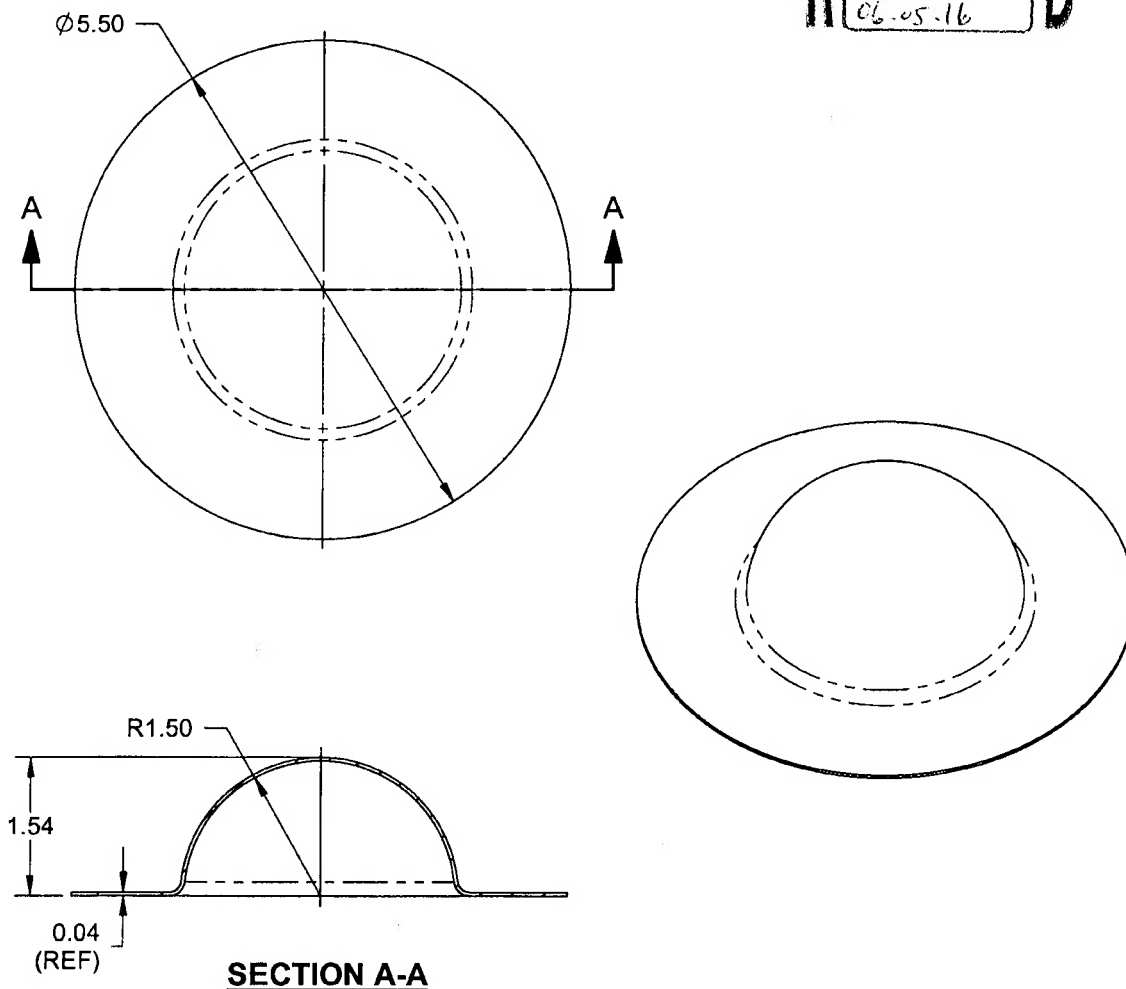
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06-05-16



D3478-9S AIR INLET SCOOP, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

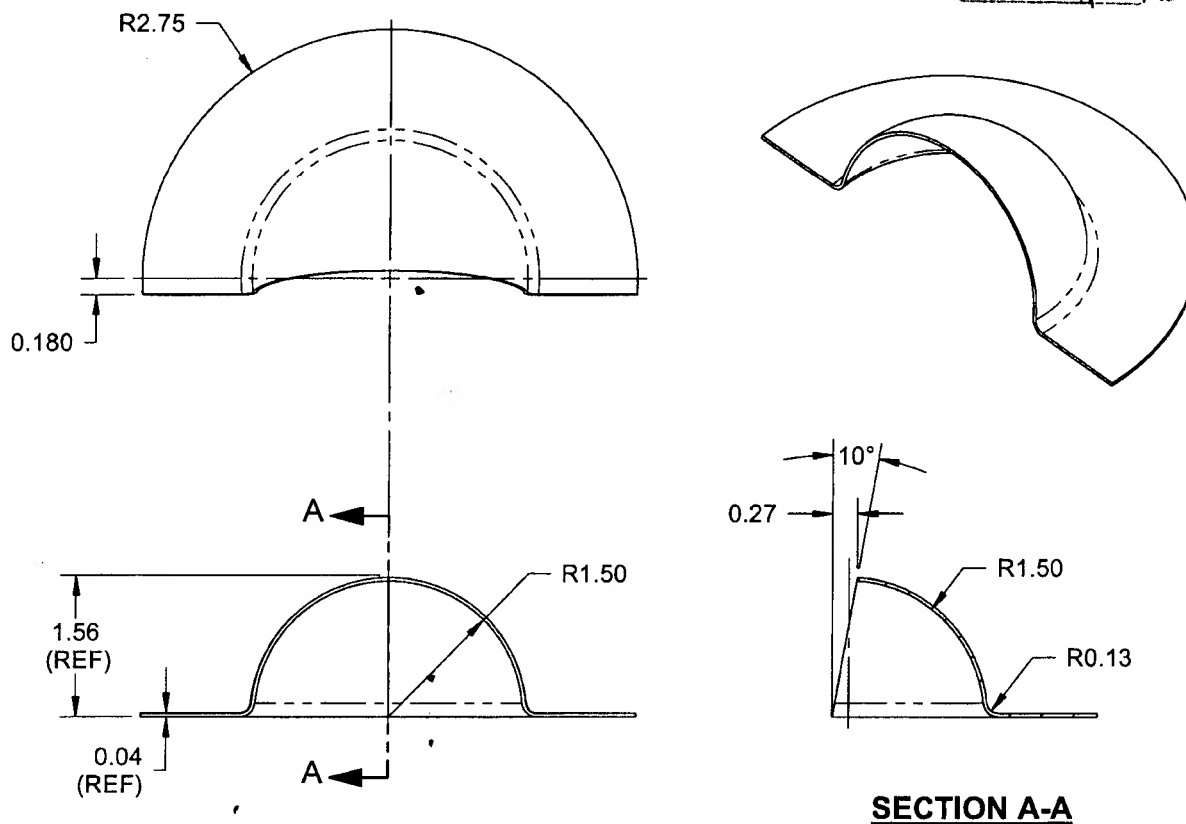
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DATE 06.05.16	TITLE AIR INLET ADAPTER		SCALE 1:2

RELEASED
06.05.16 *[Signature]***D3478-9 INLET SCOOP****NOTES:**

- 1) MATERIAL: MAKE FROM D3478-9S
- 2) IDENTIFY WITH DART P/N D3478-9 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 21

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Melanie Fartoux
Joint Welding Procedure Spot Welding
Part number and Job number D3478-041 B28520

TEST WELDS REQUIRED

BASE METAL 304 2G WELDING PROCESS Spot
Penetration Complete ☒ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/03 Qualifier Sylvie Boucher